

Work Order ID 64753-2

Thursday, December 16, 2010 9:48:19 AM

Page 1

Item ID: D3179-041

Revision ID:

Item Name: Fwd Litter Tie Down

Start Date: 12/16/2010 Start Qty: 6.00

Required Date: 12/21/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

QC:

Date: 10-12-16 Tooling:




Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

| Sequence ID/<br>Work Center ID  | Operation<br>Description                                  | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr  | Revision Nbr  |                      |         |        |              |               |               |                  |                |
| D3179   | Rev C   |                      |         |        |              |               |               |                  |                |
| 100   | BAND SAW  | 0.00                 |         |        |              |               |               |                  |                |
|    | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Bandsaw   | Cut blanks: 12.150" long                                  |                      |         |        |              |               |               |                  |                |
| Jeaspa Bandsaw  |   |                      |         |        |              |               |               |                  |                |
| 110   | HAAS CNC VERTICAL MACHINING #1                            | 0.00                 |         |        |              |               |               |                  |                |
|  | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| HAAS 1  | 1- Mill as per Folio FA297 Rev: AA & Dwg D3179-1 Rev: C-2 |                      |         |        |              |               |               |                  |                |
| HAAS CNC vertical machine #1  | Deburr per dwg D3179-1                                    |                      |         |        |              |               |               |                  |                |
| 120   | QC2- Inspect parts off machine FAI/FAIB                   | 0.00                 |         |        |              |               |               |                  |                |
|  | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| QC  |   |                      |         |        |              |               |               |                  |                |
| Quality Control   |   |                      |         |        |              |               |               |                  |                |

SPLIT

RUSH



Cust Item ID:

Customer:



0.00

0.00

0.00

0.00

0.00

0.00

SL 10/12/20 (6)

SL 10/12/22 (6)

SL 10/12/22 (6)

# Work Order ID 64753

Thursday, December 16, 2010 9:48:19 AM

Page 2

Item ID: D3179-041

Accept

Revision ID:

Item Name: Fwd Litter Tie Down

Start Date: 12/16/2010 Start Qty: 6.00

Required Date: 12/21/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

HA 10/12/22

6

0

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

6 BR 10-12-23

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

HL 10/12/23

6

0

# Work Order ID 64753

Thursday, December 16, 2010 9:48:19 AM



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Item ID: D3179-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Litter Tie Down

Start Date: 12/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/21/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*Subtotal*

*(x4)*

200



Packaging

Packaging

Identify as per dwg & Stock Location

*225*

0.00

Memo

0.00

*11/1/20 (40) S*

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/01/20*

*MF*

*11-01-20*



# Picklist Print

Thursday, December 16, 2010 9:48:24 AM

Page 1

Work Order ID: 64753

Parent Item: D3179-041

Parent Item Name: Fw Litter Tie Down



Start Date: 12/16/2010

Start Qty: 6.00

Required Date: 12/21/2010

Required Qty: 6.00

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF  
IPP Rev:B Added Powder Coat 07-07-04 JLM  
IPP Rev:C 08-12-10 add part list DD verified by:JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

NAS1149D0332J



Washer

Purchased

No

100

Each

141.0000

3

18

Location

ST298

Loc Qty

141

Loc Code

114884

141

D2372



Quick Release

Manufactured

No

180

Each

27.0000

2

12

Location

ST012

Loc Qty

27

Loc Code

57765

2

60716

25

D2444



Pip Pin Assembly

Manufactured

No

180

Each

6.0000

1

6

Location

ST014

Loc Qty

6

Loc Code

57766

3

60154

1

64089

2

EP 11/01/19  
M116441 (12x)

EP 11/01/19  
B64755 (8x)

EP 11/01/19  
B64755 (4x)

# Picklist Print

Thursday, December 16, 2010 9:48:24 AM

Work Order ID: 64753

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down



Start Date: 12/16/2010

Required Date: 12/21/2010

Start Qty: 6.00

Required Qty: 6.00

D6201

Manufactured No

180 f

17.8468 1.0125 6.394737



"T" Extrusion

Location

Loc Qty

Loc Code

MAT05

17.84684

56424

2.11

57767

15.73684

MS21042L3

Purchased No

180 Each

1,932.000

1

6



Nut

Location

Loc Qty

Loc Code

ST300

1932

114784

9

115835

996

116373

27

116391

900

MS27039-1-13

Purchased No

180 Each

58.0000

1

6



Screw

Location

Loc Qty

Loc Code

ST292

58

110844

58



|   |               |                             |
|---|---------------|-----------------------------|
| <b>DART AEROSPACE LTD</b>                       |               | <b>Work Order:</b> 44753    |
| <b>Description:</b> Fwd Litter Tie Down Bracket |               | <b>Part Number:</b> D3179-1 |
| <b>Inspection Dwg:</b> D3179                    | <b>Rev:</b> C | <b>Page 1 of 1</b>          |

### FIRST ARTICLE INSPECTION CHECKLIST

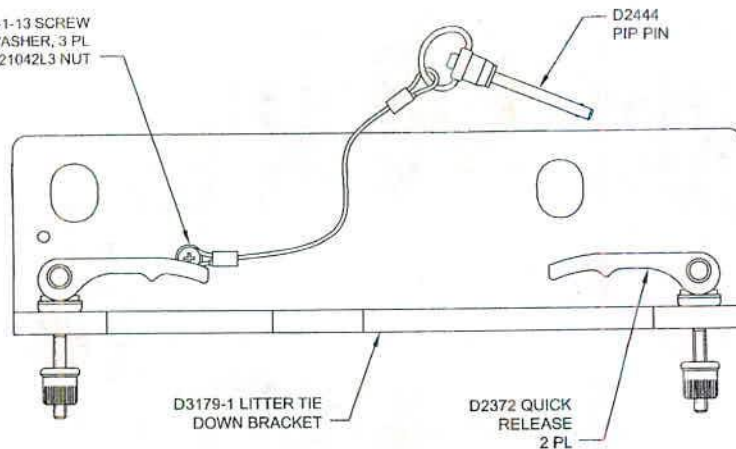
☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments    |
|-------------------|---------------|------------------|--------|--------|----------------------|-------------|
| 1.00              | +/-0.030      | 1.001            | ✓      |        | vern 2-3             |             |
| Ø0.242            | +0.005/-0.001 | .243             | ✓      |        |                      |             |
| R0.40             | +/-0.030      | .40              | ✓      |        |                      |             |
| 0.375             | +/-0.010      | .364             | ✓      |        |                      | "stock mat" |
| Ø0.191            | +0.005/-0.001 | .192             | ✓      |        |                      |             |
| 1.00              | +/-0.030      | 1.002            | ✓      |        |                      |             |
| 1.70              | +/-0.030      | 1.690            | ✓      |        | II-G                 |             |
| 4.00              | +/-0.030      | 3.990            | ✓      |        |                      |             |
| 1.50              | +/-0.030      | 1.502            | ✓      |        |                      |             |
| 0.750             | +/-0.010      | .750             | ✓      |        |                      |             |
| 1.50              | +/-0.030      | 1.501            | ✓      |        |                      |             |
| 10.500            | +/-0.010      | 10.500           | ✓      |        | VERA CNG-02          |             |
| 4.250             | +/-0.010      | 4.250            | ✓      |        |                      |             |
| 0.750             | +/-0.010      | .751             | ✓      |        |                      |             |
| 1.000             | +/-0.010      | .999             | ✓      |        |                      |             |
| 12.00             | +/-0.030      | 12.003           | ✓      |        | VERA CNG-02          |             |
| 1.00              | +/-0.030      | 1.002            | ✓      |        | VERA 2-3             |             |
| 8.00              | +/-0.030      | 8.00             | ✓      |        |                      |             |
| Ø0.191            | +0.005/-0.001 | .192             | ✓      |        |                      |             |
| R0.37             | +/-0.030      | .375             | ✓      |        |                      |             |
| 0.97              | +/-0.030      | .965             | ✓      |        |                      |             |
| 1.86              | +/-0.030      | 1.854            | ✓      |        | II-G                 |             |
| 1.750             | +/-0.010      | .750             | ✓      |        |                      | "stock mat" |
| 0.375             | +/-0.010      | .366             | ✓      |        |                      |             |
| 2.875             | +/-0.010      | 2.875            | ✓      |        |                      |             |
| 0.500             | +/-0.010      | .501             | ✓      |        |                      |             |
| 1.250             | +/-0.010      | 1.253            | ✓      |        |                      |             |
| 1.625             | +/-0.010      | 1.628            | ✓      |        |                      |             |
| 3.31              | +/-0.030      | 3.312            | ✓      |        |                      |             |

|                        |             |                        |            |                                |                 |
|------------------------|-------------|------------------------|------------|--------------------------------|-----------------|
| <b>Measured by:</b> SL |             | <b>Audited by:</b> G.A |            | <b>Prototype Approval:</b> N/A |                 |
| <b>Date:</b> 10/12/22  |             | <b>Date:</b> 10/12/22  |            | <b>Date:</b> N/A               |                 |
| <b>Rev</b>             | <b>Date</b> | <b>Change</b>          | <b>P/O</b> | <b>Revised by</b>              | <b>Approved</b> |
| A                      | 09.04.05    | New Issue              | D3179-041  | KJ/DD                          | MA              |

D  
C  
B  
A

MS27039-1-13 SCREW  
NAS1149D0332J WASHER, 3 PL  
MS21042L3 NUT



D3179-1 LITTER TIE  
DOWN BRACKET

D2372 QUICK  
RELEASE  
2 PL

D2444  
PIP PIN

**D3179-041 FWD LITTER TIE DOWN BRACKET**

**NOTES:**

1) D3179-041 WEIGHT: 2.79 lbs

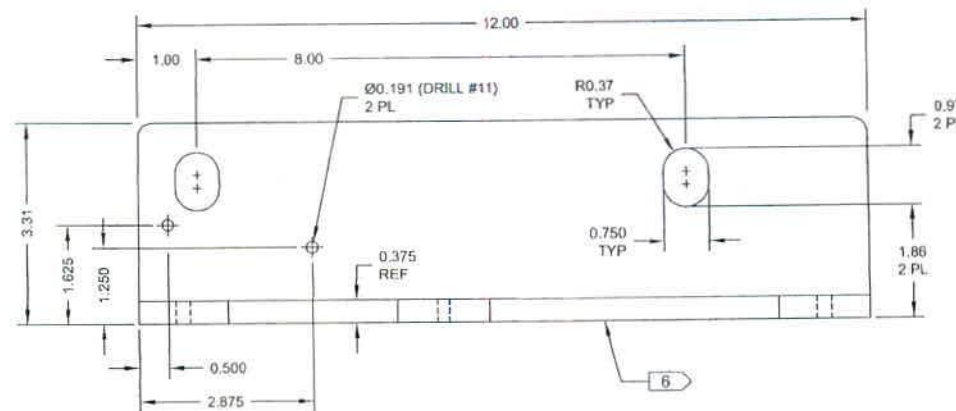
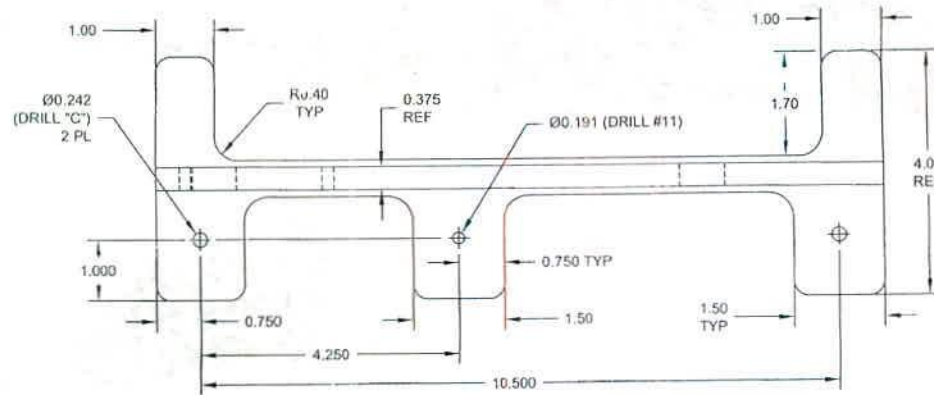
| Item | Qty<br>-041 | Part Number   | Description             |
|------|-------------|---------------|-------------------------|
| 1    | X           | D3179-041     | FWD LITTER TIE DOWN     |
| 2    | 2           | D2372         | QUICK RELEASE           |
| 3    | 1           | D2444         | PIP PIN                 |
| 4    | 1           | D3179-1       | LITTER TIE DOWN BRACKET |
| 5    | 1           | MS21042L3     | NUT                     |
| 6    | 1           | MS27039-1-13  | SCREW                   |
| 7    | 3           | NAS1149D0332J | WASHER (OR AN960JD10L)  |

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44373  
BA/10-12-16

REUSED  
(08/11/21) M.B.

|            |  |  |              |
|------------|--|--|--------------|
| C          | ADD D3179-041 & PART LIST (ZN B6-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE PIN | RF   | 08.11.07     |
| B          | REFORMAT DRAWING; FINISH WAS ANODIZE   | DC   | 07.06.06     |
| A          | NEW ISSUE  | RF   | 02.12.09     |
| REV.       | DESCRIPTION  | BY   | DATE         |
| DESIGN     | BW   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | RF   |  |              |
| CHECKED    |  | DRAWING NO.  | REV. C       |
| MFG. APPR. |  | D3179  | SHEET 1 OF 2 |
| APPROVED   |  | TITLE  | SCALE        |
| DE APPR.   |  | LITTER TIE DOWN BRACKET  | NTS          |
| DATE       | 08.11.07   | COPYRIGHT © 1995 BY DART AEROSPACE LTD<br><small>"THIS DOCUMENT IS FRAGILE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD."</small> |              |

D  
C  
B  
A



**D3179-1 LITTER TIE DOWN BRACKET**

**NOTES:**

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T6511 PER QQ-A-200/B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3179-1 USING FINE POINT PERMANENT INK MARKER ON THE BOTTOM FACE
- 7) WEIGHT: 2.3 lbs

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | BW       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN      | RF       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED    | PU       | DRAWING NO.                            | REV. C       |
| MFG. APPR. |          | D3179                                  | SHEET 2 OF 2 |
| APPROVED   |          | TITLE                                  | SCALE        |
| DE APPR.   |          | LITTER TIE DOWN BRACKET                | NTS          |
| DATE       | 08.11.07 | COPYRIGHT © 1995 BY DART AEROSPACE LTD |              |

LEASED

W064753